

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-185 **Date Opened:** 03 November 2017 **Title:** Fabrication**Aircraft OEM:** Bell **Aircraft Model:** 206L/407 **Product Type:** Beams **Product Model:** Standard Low **Quantity:** 10/10**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69830	5	Forward Beam	JC
69831	4	Aft Beam	JC

Traveller**Component Completion**

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

10/10
P
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking Tags (White) Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
JC
N/A
N/A
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

JC
N/A
N/A

Work performed by:

Print: J. CLARKE

ICC / Dual Inspection performed by:

Print: J. REEVE

Work Order closed by:

Print: J. CLARKE

Approved Manufacturing Facility 73-04

Sign: [Signature]Sign: [Signature]Sign: [Signature]

Form 20.D.03

SCA: ADD2SCA: ADD1SCA: ADD2Date: 09 MAY 2018Date: 05 MAY 2018Date: 02 AUG 2019

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Tube (Forward Beam) No. of pieces: 10

Manufacturer: Aero Design Ltd.

Part No.: 69830-13 Serial/Batch No.: 15073/17050

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: Machining, Weld, Powder
Coat, Inspection

Signature: JH/CEL

Date: 07 DEC 2017 Lic. No. / SCA AD 02

In Process



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AMF 73-04

In Process

Remarks

Forward Beam 41.18"



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Tube (Forward Beam) No. of pieces: 10

Manufacturer: Aero Design Ltd.

Part No.: 69830-14

Serial/Batch No.: 15073/17050

TTSN: NA

TSO: NA

Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: Machining, Weld, Powder Coat, Inspection

Signature: Jff Cal.

Date: 07 DEC 2017

Lic. No. / SCA AD02

In Process



Aero Design Ltd.

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AMF 73-04

In Process

Forward Beam

Remarks

12.50"



Aero Design Ltd.

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AMF 73-04

Nomenclature: Strap No. of pieces: 100.

Manufacturer: MAF

Part No.: 69830-16 Serial / Batch No.: 13083

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: _____

Remaining Tasks to be Performed: Install

Signature: David May

Date: May 2015 Lic. No. / SCA AD-05

Form# 20.E.03 Rev. 1 24 April 2014

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Corner Tube No. of pieces: 10

Manufacturer: Aero Design Ltd.

Part No.: 69831-14 Serial/Batch No.: 15073/17050

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-185

Remaining Tasks to be Performed: Machining, Weld, Powder Coat, Inspection

Signature: JH Cel.

Date: 07 DEC 2017

Lic. No. / SCA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Aft. Beam 2.65" ^uRemarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Tube (Aft. Beam) No. of pieces: 10

Manufacturer: Aero Design Ltd.

Part No.: 69831-13 Serial/Batch No.: 15073/17050

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: Machining, Weld, Powder Coat, Inspection.

Signature: JH cel.

Date: 07 DEC 2017 Lic. No. / SCA AD 02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Aft. Beam 36.25" Remarks

Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Aft. Beam 12.88" Remarks



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

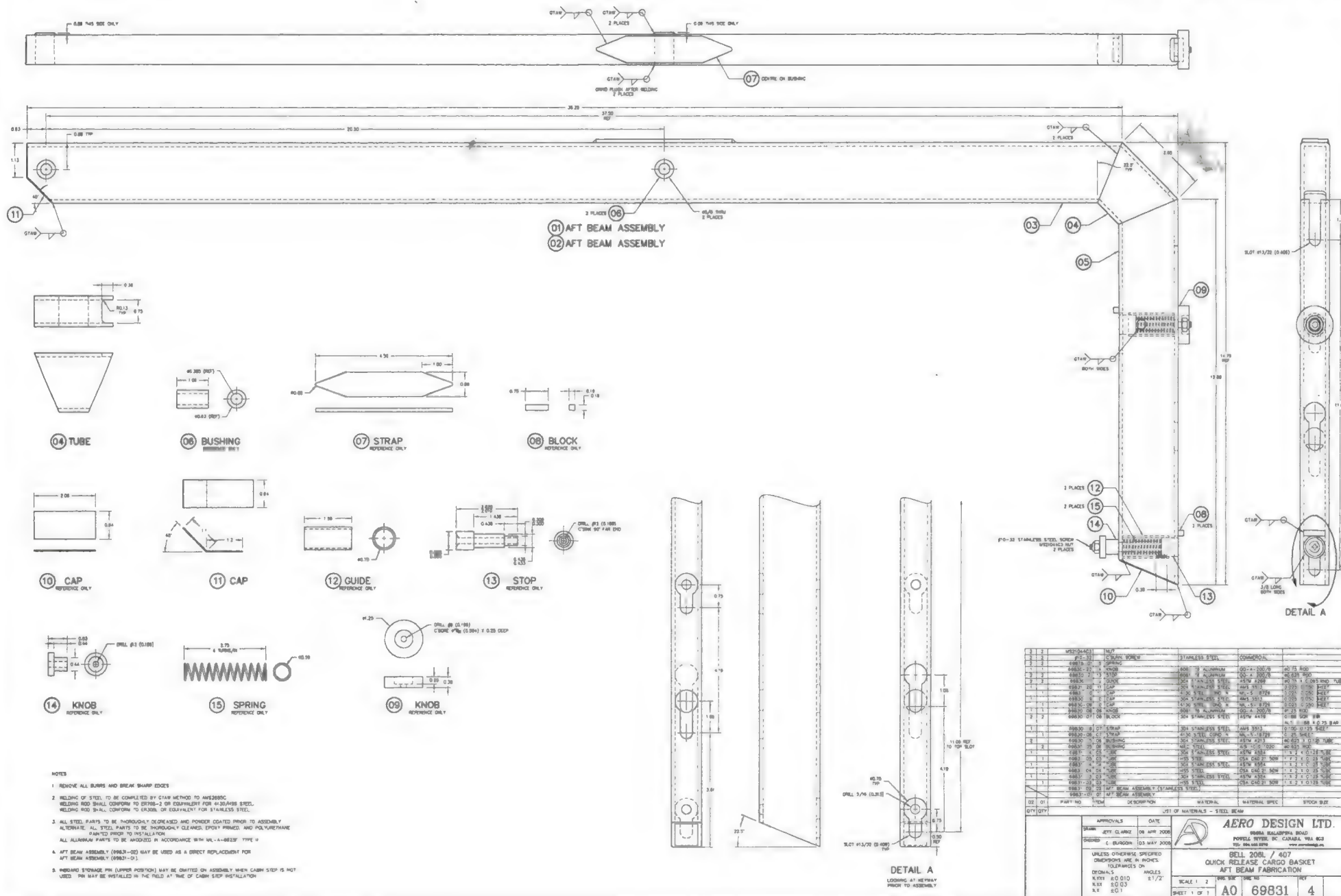
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Tube No. of pieces: 10
Manufacturer: Aero Design Ltd
Part No.: 64831-14 Serial/Batch No.: 15073/17050
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-185
Remaining Tasks to be Performed: Machining, weld, powder
coat, Inspection
Signature: [Signature]
Date: 07 DEC 2017 Lic. No. / SCA A002

In Process

REV.	DESCRIPTION OF CHANGE	DATE
1	BEAM MODIFIED TO ACCOMMODATE SLIDING DOOR	08/29/75
2	BEAM MODIFIED FOR 1' REINFORCING ATTACHMENT	07/77
3	REINFORCING ATTACHMENT FOR STEP INSTALLATION	11/79
4	WALL BEHIND SLIDING STRAP BLOCK CAP MATERIALS UPDATED	08/11/79



MOUNTING BEAM FABRICATION – 69830/69831

General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision ^{5 DC} ~~3~~ – Forward Beam

69831, Revision ^{4 DC} ~~3~~ – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

- Work Order: 2017-185 Batch Quantity: 5 Aft Complete (initial or SCA #)
- Date Open: 03 Nov 2017
- | | | | | | |
|--|---|---|---|---|---|
| | 1 | 2 | 3 | 4 | 5 |
|--|---|---|---|---|---|
1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02 JF JF JF JF JF ^{AD} 73-04 02
 - a. Cut 1 x 2 x 0.12 material as indicated on drawings.
 - i. 69830-02: 69830-13 (long tube), 69830-14 (down tube)
 - ii. 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)
 - b. Record material PO on attached material list.
 - c. De-burr cut ends using a sanding disc on a die-grinder.
 - d. Remove writing on tubes with acetone.
 - e. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.
 2. CNC Machining – 69830-02 / 69831-02 NR NR NR NR NR ^{AD} 73-04 02
 - a. Run CNC programs to machine keyways, slots and holes in component parts.
 - b. De-burr keyways, slots and holes.
 - c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.
 3. Beam Fabrication – Components – 69830-02 / 69831-02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

 - a. Shear and bend caps: 69830-19, 69830-20, 69831-20.
 - b. Cut and turn 69830-15 bushings and 69830-11 guide tubes:
 - i. Cut stock to length + 0.03-0.06".
 - ii. Face one end flat @ 1000 RPM.
 - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - iv. Setup stop and face other end to length @ 1000 RPM.
 - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
 - c. Cut 69830-07 blocks.
 - d. Record component POs / WOs on attached material list.

(MOUNTING BEAM FABRICATION – 69830/69831

1 AD 73-04 05
2 AD 73-04 05
3 AD 73-04 05
4 AD 73-04 05
5 Completed AD 73-04 05 (initial or SCA#)

4. Beam Welding – 69830-02 / 69831-02

- TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- TIG weld components using ER308L rod:
 - 69830-16 strap to beam, centre on bushing.
 - 69830-07 stops over bottom outboard keyway and top inboard keyway.
 - 69830-19, 69830-20, 69831-20 caps.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for finishing.

AD 73-04 02
AD 73-04 02
AD 73-04 02
AD 73-04 02
AD 73-04 02

5. Beam Finishing – 69830-02 / 69831-02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- Straighten beams at strap using hydraulic press.
 - Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - Use a block to distribute press loads, about 2" wide
 - Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- Straighten beams into plane using hydraulic press.
 - Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - Pressurize ram to 800 psi to hold beam.
 - Clamp a snipe tube to down tube.
 - Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - Check beams for plane, repeat steps ii-v if required.
- Break sharp edges off strap and stops using sanding disc on die-grinder.
- Tag in-progress parts for inspection.

MOUNTING BEAM FABRICATION – 69830/69831

6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

- Inspect beams 69830-02 and 69831-02 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

7. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

8. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Green tag completed beam assemblies and place into stock.

1	2	3	4	5
AD 73-04 01	AD 73-04 01	AD 73-04 01	Complete (initial or SCA #)	Complete (initial or SCA #)
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

MOUNTING BEAM FABRICATION – 69830/69831

General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision ^{59c.} ~~3~~ – Forward Beam

69831, Revision ^{40c.} ~~3~~ – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

Work Order: 2017-185 Batch Quantity: 5 Aft Complete
 Date Open: 03 Nov 2017 6 7 8 (initial or SCA #) 9 10

1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02 JC Jf. Jf. Jf. Jf. ^{AD} 73-04 02

a. Cut 1 x 2 x 0.12 material as indicated on drawings.

i. 69830-02: 69830-13 (long tube), 69830-14 (down tube)

ii. 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)

b. Record material PO on attached material list.

c. De-burr cut ends using a sanding disc on a die-grinder.

d. Remove writing on tubes with acetone.

e. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 69830-02 / 69831-02 NR NR NR NR NR ^{AD} 73-04 02

a. Run CNC programs to machine keyways, slots and holes in component parts.

b. De-burr keyways, slots and holes.

c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components – 69830-02 / 69831-02 ^{AD} 73-04 02 ^{AD} 73-04 02 ^{AD} 73-04 02 ^{AD} 73-04 02 ^{AD} 73-04 02

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

a. Shear and bend caps: 69830-19, 69830-20, 69831-20.

b. Cut and turn 69830-15 bushings and 69830-11 guide tubes:

i. Cut stock to length + 0.03-0.06".

ii. Face one end flat @ 1000 RPM.

iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.

iv. Setup stop and face other end to length @ 1000 RPM.

v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.

c. Cut 69830-07 blocks.

d. Record component POs / WOs on attached material list.

AD⁶ AD⁷ 8 AD⁹ 10 Complete
 73-04 73-04 73-04 73-04 (initial or SCAD) 73-04
 05 05 05 05 05

4. Beam Welding – 69830-02 / 69831-02

- TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- TIG weld components using ER308L rod:
 - 69830-16 strap to beam, centre on bushing.
 - 69830-07 stops over bottom outboard keyway and top inboard keyway.
 - 69830-19, 69830-20, 69831-20 caps.
- Record component and welding rod POs / WO's on attached material list.
- Tag in-progress parts for finishing.

AD AD AD AD AD
 73-04 73-04 73-04 73-04 73-04
 02 02 02 02 02

5. Beam Finishing – 69830-02 / 69831-02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- Straighten beams at strap using hydraulic press.
 - Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - Use a block to distribute press loads, about 2" wide
 - Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- Straighten beams into plane using hydraulic press.
 - Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - Pressurize ram to 800 psi to hold beam.
 - Clamp a snipe tube to down tube.
 - Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - Check beams for plane, repeat steps ii-v if required.
- Break sharp edges off strap and stops using sanding disc on die-grinder.
- Tag in-progress parts for inspection.

MOUNTING BEAM FABRICATION – 69830/69831

6 7 8 9 10

Complete

(initial or SCA #)

6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

a. Inspect beams 69830-02 and 69831-02 for conformity to drawing.

b. Tag in-progress parts ready for powder coating.

AD 73-04 01 AD 73-04 01 AD 73-04 01 AD 73-04 01

7. Powder Coating

a. Parts are to be powder coated white in accordance with commercial practices.

b. Record powder coating PO.

c. Inspect powder coating on receiving.

d. Tag in-progress parts ready for final assembly.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

8. Final Assembly

To be completed after powder coating.

a. Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.

b. Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.

c. Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.

d. Adhere P/N placard to top surface of beam, between strap and end on top surface.

e. Green tag completed beam assemblies and place into stock.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

Work Order: 2017-185Material Tracking Sheet
Bell 206L / 407 Aft Mounting Beams

1 of 2

Date Open: 03 Nov 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>10</u>		69831-02	Aft Beam Assembly		
Step 1				<i>Fabrication</i>		
	. 1		69831-13	Tube	304 Stainless, 1x2x0.125 tube	<u>15073/17050</u>
	. 1		69831-14	Tube	304 Stainless, 1x2x0.125 tube	<u>15073/17050</u>
	. 1		69831-15	Tube	304 Stainless, 1x2x0.125 tube	<u>15073/17050</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>Fabrication</i>		
	. 2		69830-15	Bushing	304 Stainless, 5/8" x 0.120 tube	<u>17116</u>
	. 1		69830-16	Strap	304 Stainless, 0.100-125" Sheet	<u>15046/13083</u>
	. 1		69830-17	Block	304 Stainless, 3/16" bar	<u>15073</u>
	. 1		69830-19	Cap	304 Stainless, 0.025-0.050" Sheet	<u>17081</u>
	. 1		69830-20	Cap	304 Stainless, 0.025-050" Sheet	<u>10037</u>
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	<u>15073</u>
Step 4				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>14005/17066</u>
Step 5				<i>Straightening</i>	<i>None</i>	
Step 6				<i>Inspection</i>	<i>None</i>	
Step 7				<i>Powder Coating</i>		
					<i>PAINT</i>	<u>15016 15017 15019 15026</u>
					<i>(1) (2) (2) (4) (1)</i>	

03 November 2017
Revision 1

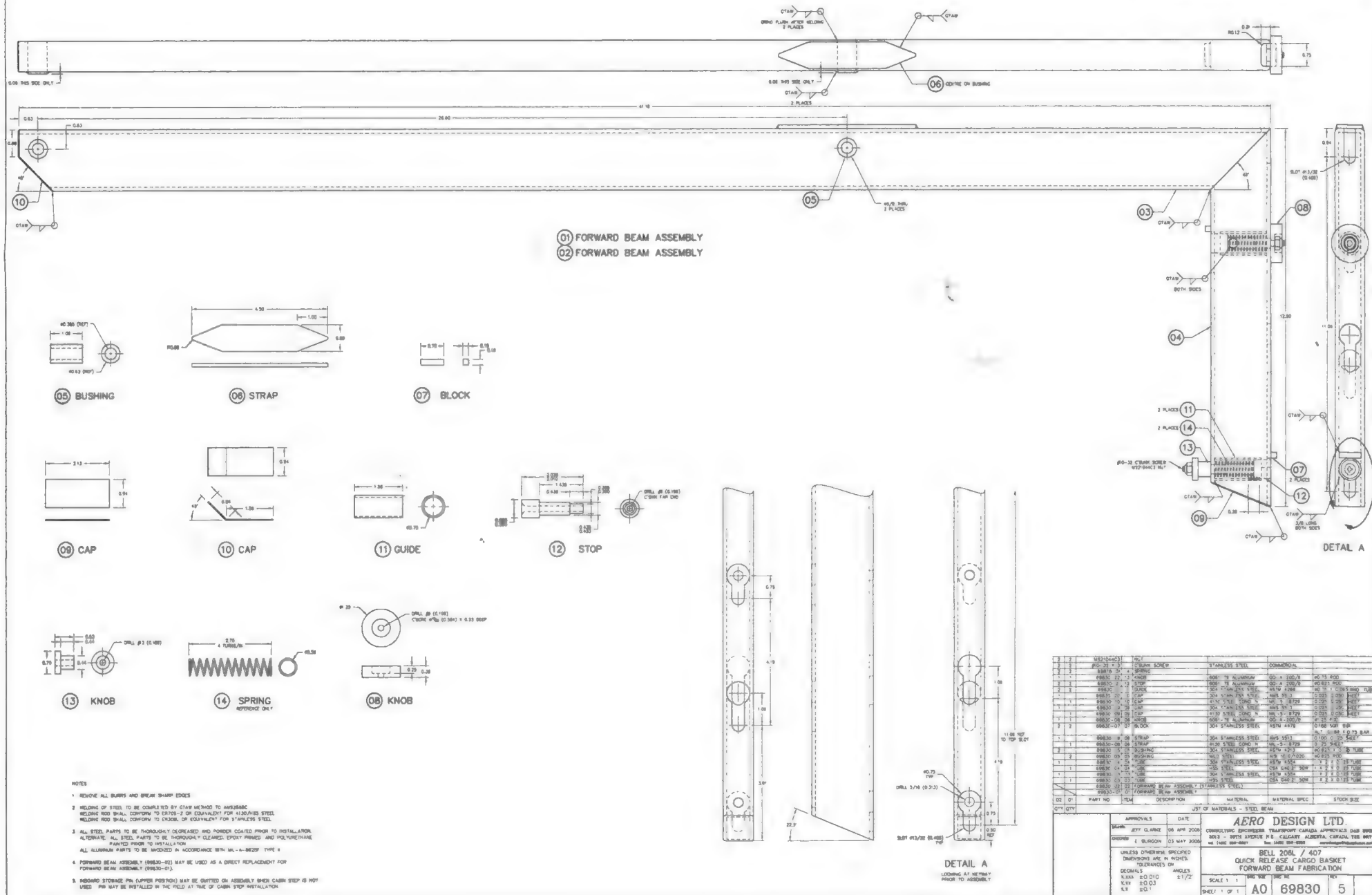
Page 1 of 2

Work Order: 2017-185Material Tracking Sheet
Bell 206L / 407 Aft Mounting Beams

2 of 2

Date Open: 03 Nov 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Final Assembly</i>		
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	See PDS
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	See PDS
	. 1		69830-23	Spring	15mm x 70 mm Spring	See PDS
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	See PDS
	. 1		MS21044C3	Nut		See PDS
Step 8.c.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	See PDS
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	See PDS
	. 1		69830-23	Spring	15mm x 70 mm Spring	See PDS
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	See PDS
	. 1		MS21044C3	Nut		See PDS
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2"	

[illegible]

1-5
MOUNTING BEAM FABRICATION – 69830/69831

General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision ^{58c}3 – Forward Beam
69831, Revision ^{49c}3 – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

Work Order: 2017-185

Batch Quantity: 5 Forward

Complete
(initial or SCA #)

Date Open: 03 NOV 2017

1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02

JS JS JS JS JS ^{AD}13-04 02

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 69830-02: 69830-13 (long tube), 69830-14 (down tube)
 - 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 69830-02 / 69831-02

NR NR NR NR NR ^{AD}13-04 02

- Run CNC programs to machine keyways, slots and holes in component parts.
- De-burr keyways, slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components – 69830-02 / 69831-02

^{AD}13-04 02 ^{AD}13-04 02 ^{AD}13-04 02 ^{AD}13-04 02 ^{AD}13-04 02

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear and bend caps: 69830-19, 69830-20, 69831-20.
- Cut and turn 69830-15 bushings and 69830-11 guide tubes:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list.

MOUNTING BEAM FABRICATION – 69830/69831

1	2	3	4	5
AD	AD	AD	AD	Complete
73-04	73-04	73-04	73-04	(initial or SCA #)
05	05	05	05	73-04
				05

4. Beam Welding – 69830-02 / 69831-02

- TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- TIG weld components using ER308L rod:
 - 69830-16 strap to beam, centre on bushing.
 - 69830-07 stops over bottom outboard keyway and top inboard keyway.
 - 69830-19, 69830-20, 69831-20 caps.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for finishing.

5. Beam Finishing – 69830-02 / 69831-02

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
02	02	02	02	02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- Straighten beams at strap using hydraulic press.
 - Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - Use a block to distribute press loads, about 2" wide
 - Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- Straighten beams into plane using hydraulic press.
 - Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - Pressurize ram to 800 psi to hold beam.
 - Clamp a snipe tube to down tube.
 - Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - Check beams for plane, repeat steps ii-v if required.
- Break sharp edges off strap and stops using sanding disc on die-grinder.
- Tag in-progress parts for inspection.

MOUNTING BEAM FABRICATION – 69830/69831

6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

- Inspect beams 69830-02 and 69831-02 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

7. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

8. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Green tag completed beam assemblies and place into stock.

1 2 3 4 5

AD 73-04 01 AD 73-04 01 AD 73-04 01 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

Complete (initial or SCA#) AD 73-04 01

MOUNTING BEAM FABRICATION – 69830/69831

6-10

General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision ⁵⁹⁶ ~~3~~ – Forward Beam

69831, Revision ⁴⁹⁶ ~~3~~ – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

Work Order: 2017-185 Batch Quantity: 5 Forward Complete (initial or SCA #)

Date Open: 03 Nov 2017

1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02

- Cut 1 x 2 x 0.12 material as indicated on drawings.
 - 69830-02: 69830-13 (long tube), 69830-14 (down tube)
 - 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder.
- Remove writing on tubes with acetone.
- Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining – 69830-02 / 69831-02

- Run CNC programs to machine keyways, slots and holes in component parts.
- De-burr keyways, slots and holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components – 69830-02 / 69831-02

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- Shear and bend caps: 69830-19, 69830-20, 69831-20.
- Cut and turn 69830-15 bushings and 69830-11 guide tubes:
 - Cut stock to length + 0.03-0.06".
 - Face one end flat @ 1000 RPM.
 - De-burr outside with a file and inside with de-burring tool at 300 RPM.
 - Setup stop and face other end to length @ 1000 RPM.
 - De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Cut 69830-07 blocks.
- Record component POs / WOs on attached material list.

MOUNTING BEAM FABRICATION – 69830/69831

6 7 8 9 10
AD AD AD AD Complete
73-04 73-04 73-04 73-04 (initial or SCA #)
05 05 05 05 73-04
05

4. Beam Welding – 69830-02 / 69831-02

- TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- TIG weld components using ER308L rod:
 - 69830-16 strap to beam, centre on bushing.
 - 69830-07 stops over bottom outboard keyway and top inboard keyway.
 - 69830-19, 69830-20, 69831-20 caps.
- Record component and welding rod POs / WOs on attached material list.
- Tag in-progress parts for finishing.

5. Beam Finishing – 69830-02 / 69831-02

AD AD AD AD AD
73-04 73-04 73-04 73-04 73-04
02 02 02 02 02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- Straighten beams at strap using hydraulic press.
 - Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
 - Use a block to distribute press loads, about 2" wide
 - Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
 - Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- Straighten beams into plane using hydraulic press.
 - Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
 - Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
 - Pressurize ram to 800 psi to hold beam.
 - Clamp a snipe tube to down tube.
 - Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
 - Check beams for plane, repeat steps ii-v if required.
- Break sharp edges off strap and stops using sanding disc on die-grinder.
- Tag in-progress parts for inspection.

6 7 8 9 10

MOUNTING BEAM FABRICATION – 69830/69831

Complete

6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

- Inspect beams 69830-02 and 69831-02 for conformity to drawing.
- Tag in-progress parts ready for powder coating.

7. Powder Coating

- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag in-progress parts ready for final assembly.

8. Final Assembly

To be completed after powder coating.

- Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.
- Adhere P/N placard to top surface of beam, between strap and end on top surface.
- Green tag completed beam assemblies and place into stock.

AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

Work Order: 2017-185Material Tracking Sheet
Bell 206L/407 Forward Mounting Beams

1 of 2

Date Opened: 03 Nov 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	10		69830-02	Forward Beam Assembly		
Step 1				Fabrication		
	. 1		69830-13	Tube	304 Stainless, 1x2x0.125 tube	15073/17050
	. 1		69830-14	Tube	304 Stainless, 1x2x0.125 tube	15073/17050
Step 2				Machining	None	
Step 3				Fabrication		
	. 2		69830-15	Bushing	304 Stainless, 5/8" x 0.120 tube	17116
	. 1		69830-16	Strap	304 Stainless, 0.100-0.125" Sheet	15046
	. 1		69830-17	Block	304 Stainless, 3/16" bar	15073
	. 1		69830-19	Cap	304 Stainless, 0.025-0.050" Sheet	17081
	. 1		69830-20	Cap	304 Stainless, 0.025-0.050" Sheet	10037
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	15073
Step 4				Welding		
	. A/R		--	Welding Rod	ER308L	17066 / 14605
Step 5				Straightening	None	
Step 6				Inspection	None	
Step 7				Powder Coating	PAINT	18016 18017 18019
					(1)	(2) (1) (6)
03 November 2017 Revision 1						

Work Order: 217-185Material Tracking Sheet
Bell 206L/407 Forward Mounting Beams

'2 of 2'

Date Opened: 03 Nov 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Final Assembly</i>		
Step 8.a.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	see PDS
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	see PDS
	. 1		69830-23	Spring	15mm x 70 mm Spring	see PDS
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	see PDS
	. 1		MS21044C3	Nut		see PDS
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	See PDS
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	See PDS
	. 1		69830-23	Spring	15mm x 70 mm Spring	See PDS
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	See PDS
	. 1		MS21044C3	Nut		See PDS
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2"	

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-185

Batch Quantity: 40

Complete
(initial or SCA #)

Date Open: 03 NOV 2017

Part Number: 69830 - 15

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 17116

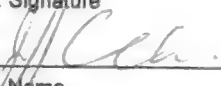
2. Turn stock material:

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0249
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO M07739
6. Item 1.	7. Description Forward Beam	8. Part Number 69830-02	9. Qty. 1	10. Serial/Batch No. WO 2017-185	11. Status/Work New
12. Remarks Certification data: TCCA STC SH00-48					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 13 Oct 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

CUSTOM HELICOPTERS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407/206L FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Jan 26/2018 Lic. No. / SCA AD 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps . 5. ✓

6. ✓

7. ✓

8. ✓

POWDER PO 18019

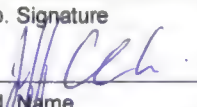
13 OCT 2015



Description: Beam Pin

WO# 2017-185

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0037	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-185	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Beam	69830-02	1	N/A	New	
2.	Aft Beam	69831-02	1			
12. Remarks Black						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 22 Feb 2018		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Air STASIA



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

Painted Black 22 Feb 2018 J.E.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 FWD Beqm No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: Durham

Date: Jan 26/2018

Lic. No. / SCA

In Process

AD
73-04
05

Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# 2017-185

Avr SHAcTA

B407 Two Beam

22 FEB 2018

From PO or WO #	Quantity	Description	Part Number	For WO #
17044	1	Pin	69830-21	
17044	1	Knob	69830-22	
15071	1	Spring	69878-01	
17029	1	#10-32x3 Screw	commercial	
16080	1	Nut	MS21044C3	
17044	1	PIN	69830-21	
2017-54	1	KNOB	69830-02	
15071	1	SPRING	69878-01	
16016	1	#10 32x25 Screw	commercial	
16080	1	NUT	MS21044C3	
2017-155	1	B407 FWD BATT	69830-02	



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Mantz **AD**

Date: Jan 26 / 2018 Lic. No. / SCA **73-04**

05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step 5. ✓	
6. ✓	
7. ✓	Painted Black 02 Feb 2018 JC
8. ✓	

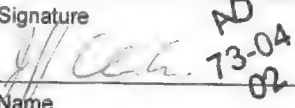
B407 AFT Beam

A

Description: Beam Pin

WO# 2017-185

From PO or WO #	Quantity	Description	Part Number	For WO #
17044	1	Pin	69830-21	
17044	1	Knob	69830-22	
15071	1	Spring	69878-01	
17029	1	#10-32x3 Screw	commercial	
16080	1	Nut	MS21044C3	
17044	1	PIN	69830-21	
2017-59	1	KNOB	69830-22	
15071	1	SPRING	69878-01	
16016	1	#10-32 x 2.5 Screw	Commercial	
17039	1	NUT	MS21044C3	
2017-185	1	B40 AFT BERM	69831-02	

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0047
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice N/A
6. Item 1.	7. Description Aft Beam	8. Part Number 69831-02	9. Qty. 1	10. Serial/Batch No. WO 2017-185	11. Status/Work New
12. Remarks Certification data: TCCA STC SH00-48					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 22 Mar 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

ALPINE



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 2066/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Monty AD
73-04

Date: Jan 26 / 2018 Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

22 MAR 2018




Description: Beam Pin

WO# 2017-185

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0054	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-185	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Beam	69830-02	1	WO 2017-185	New	
2.	Aft Beam	69831-02	1	WO 2017-185		
12. Remarks Certification data: TCCA STC SH00-48, FAA STC SR02253NY						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 26 Mar 2018		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

HELICOPTER EXPRESS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-C2 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD

Date: Jan 26 / 2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

A

Description: Beam Pin

From PO or WO #	Quantity	Description	Part Number	For WO #
17044	1	Pin	69830-21	
17044	1	Knob	69830-22	
15071	1	Spring	69878-01	
17029	1	#10-32x3 Screw	commercial	
16080	1	Nut	MS21044C3	
17044	1	Pin	69830-21	
2017-59	1	Knob	69830-22	
15071	1	Spring	69878-01	
16016	1	#10-32x3 Screw	commercial	
17039	1	Nut	MS21044C3	
2017-185	1	B407 Aft beam	69831-02	



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407/206L FWD Berr No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.:

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: Darryl Hart

Date: Jan 26 / 2018 Lic. No. / SCA NO 73-04 08

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps.	5.	✓
	6.	✓
	7.	✓
	8.	✓

26 Nov - 2018



Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# 2017-185

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0062
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice 180314-14HX
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	WO 2017-185	New
2.	Aft Beam	69831-02	1	WO 2017-185	
12. Remarks Certification data: TCCA STC SH00-48, FAA STC SR02253NY					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  PD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 03 Apr 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HELICOPTER EXPRESS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Box No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Monty AD

Date: Jan 26 / 2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Steps. 5. ✓

6. ✓

7. ✓

8. ✓



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: K-10B

No. of pieces: 1

Manufacturer: ARO

Part No.: 6-830-00

Serial/Batch No.: 10007

TTSN: 101

TSO: 101

Rem.: 101

Work Order No.: 2017-54

Remaining Tasks to be Performed: None

Signature: [Signature]

Date: FEB 20 2019

Lic. No. / SCA AD00

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

2x Removed 20 Feb 2008

2x Removed 26 Mar. 2015

Aero Design

Parts Distribution Sheet

HELICOPTER EXPRESS
03 APR 2018

Description: Beam Pin

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Martz

Date: Jan 26 / 2018 Lic. No. / SCA _____

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓
6. ✓
7. ✓
8. ✓

03 APR 2018



WO# 2017-185

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0065
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice 180323-41HX
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	WO 2017-185	New
2.	Aft Beam	69831-02	1	WO 2017-185	
12. Remarks Certification data: TCCA STC SH00-48, FAA STC SR02253NY					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations .		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 03 Apr 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

HELICOPTER EXPRESS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD

Date: Jan 26/2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 5. ✓
6. ✓
7. ✓
8. ✓

03 APR 2018



Description: Beam Pin

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206 L / 407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty **AD**
73-04

Date: Jan 26 / 2018 Lic. No. / SCA **05**

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓



Description: Beam Pin

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0071	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice 180323-27HX	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Beam	69830-02	1	WO 2017-185	New	
2.	Aft Beam	69831-02	1	WO 2017-185		
12. Remarks Certification data: TCCA STC SH00-48, FAA STC SR02253NY						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 16 Apr 2018		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

HELICOPTER EXPRESS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Jan 26/2018 Lic. No. / SCA 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

POWDER PO 18019

A

Description: Beam Pin

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD

Date: Jan 26/2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

Powder PD 18019

13 APR 2018



Aero Design

Parts Distribution Sheet

Description: Beam Pin

WO# 2017-185

From PO or WO #	Quantity	Description	Part Number	For WO #
17044	1	Pin	69830-21	
17044	1	Knob	69830-22	
15071	1	Spring	69878-01	
17029	1	#10-32x3 Screw	commercial	
16080	1	Nut	MS21044C3	
17044	1	PIN	69830-21	
2018-41	1	KNOB	69830-22	
15071	1	SPRING	69878-01	
16016	1	#10-32x2 1/2 SCREW	COMMERCIAL	
17039	1	NUT	MS21044C3	
2017-185	1	B407 AFT BEAM	69831-02	

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0088
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO 118075
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	WO 2017-185	New
2.	Aft Beam	69831-02	1	WO 2017-185	
12. Remarks Certification data: TCCA STC SH00-48					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature PD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 02 May 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

Transwest Air



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407/206L FWD Boom No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD
73-04

Date: Jan 26/2018 Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps	5. ✓	
	6. ✓	
	7. ✓	POWDER PO 15019
	8. ✓	

02 May 2018



Description: Beam Pin

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206 L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Darty AD

Date: Jan 26/2018 73-04

Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

Powder PO 16019

02 May 2018



Description: Beam Pin

WO# 2017-185

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0113	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO 4586	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Beam	69830-02	1	WO 2017-185	New	
2.	Aft Beam	69831-02	1	WO 2017-185		
12. Remarks Certification data: TCCA STC SH00-48						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  ND 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 22 May 2018		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

AERO-SMITH HELI SERVICE



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407/206L FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Martz

Date: Jan 26 / 2018 Lic. No. / SCA 73-04

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps, 5. ✓

6. ✓

7. ✓

8. ✓

Powder PO 18019

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Thant AD
73-04

Date: Jan 26 / 2018 Lic. No. / SCA 05

In Progress



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Steps. 5. ✓
6. ✓
7. ✓
8. ✓

Powder fo 18026


22 MAY 2018



Description: Beam Pin

WO# 2017-185

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0122
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice None
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	WO 2017-185	New
2.	Aft Beam	69831-02	1	WO 2017-185	
12. Remarks Certification data: TCCA STC SH00-48; FAA STC SR02253NY					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 28 May 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

ROTORWAY S.A.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Jan 26/2018

Lic. No. / SCA

In Process

NO
73-04
05



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps. 5. ✓
6. ✓
7. ✓
8. ✓

POWDER PO 18019



WO# 2017-155

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD
Date: Jan 26 / 2018 73-04
Lic. No. / SCA 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Steps. 5. ✓
6. ✓
7. ✓
8. ✓

Powder PO 15019

28 MAY 2018



WO# 2017-155

Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0187
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice None
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward Beam	69830-02	1	WO 2017-185	New
2.	Aft Beam	69831-02	1	WO 2017-185	
12. Remarks Certification data: TCCA STC SH00-48					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 25 July 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

INTERIOR HELICOPTERS



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 AFT Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69831-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Martz AD

Date: Jan 26/2018 Lic. No. / SCA 73-04

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Steps. 5. ✓

6. ✓

7. ✓

8. ✓

powder po 15019

Description: Beam Pin

WO# 2017-185

[illegible]



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407/206 L FWD Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 69830-02 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-185

Remaining Tasks to be Performed: See reverse.

Signature: David Marty

Date: Jan 26/2018 Lic. No. / SCA 73-04
05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

Steps. 5. ✓
6. ✓
7. ✓
8. ✓

Powder Po 15019



INTERIOR TEL
25 JULY 2018

Description: Beam Pin

WO# 2017-185

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013